

(19)



Europäisches Patentamt
European Patent Office
Office européen des brevets

(11) Publication number:

0 265 992
A1

(12)

EUROPEAN PATENT APPLICATION

(21) Application number: 87201986.4

(51) Int. Cl. 4: **C21D 9/56**, **C23C 14/56**,
F16J 15/16

(22) Date of filing: 16.10.87

(30) Priority: 23.10.86 NL 8602659

(43) Date of publication of application:
04.05.88 Bulletin 88/18

(84) Designated Contracting States:
AT BE CH DE ES FR GB GR IT LI LU NL SE

(71) Applicant: **N.V. BEKAERT S.A.**
Bekaertstraat 2
B-8550 Zwevegem(BE)

(72) Inventor: **Coppens, Wilfried**
Cyriel Verschaevestraat 7
B-8510 Kortrijk-Marke(BE)
Inventor: **Lievens, Hugo**
Nederzwijnaardestraat 45
B-9710 Gent(BE)

(74) Representative: **Demeester, Gabriel et al**
N.V. Bekaert S.A. Bekaertstraat 2
B-8550 Zwevegem(BE)

(54) Feed-through element for application in a vacuum apparatus; apparatus provided with such feed-through elements as well as wire material formed in such an apparatus.

(57) The invention relates to a feed-through element for application in a vacuum apparatus for the continuous feeding through of wire-shaped material to be treated at least made up of a casing and a sealing element set up therein that is in contact with the surface or the wire-shaped material during feeding through, whereby the sealing element is formed by a drawing die (20) and whereby the casing is formed by a holder (21 ; 22) for the drawing die (20), at least a part of the holder (21 ; 22) being connected in a gastight way to a partition wall of the vacuum apparatus (1) and whereby the drawing die (20) and the holder (21 ; 22) act together in sealing relation (see figure 2).

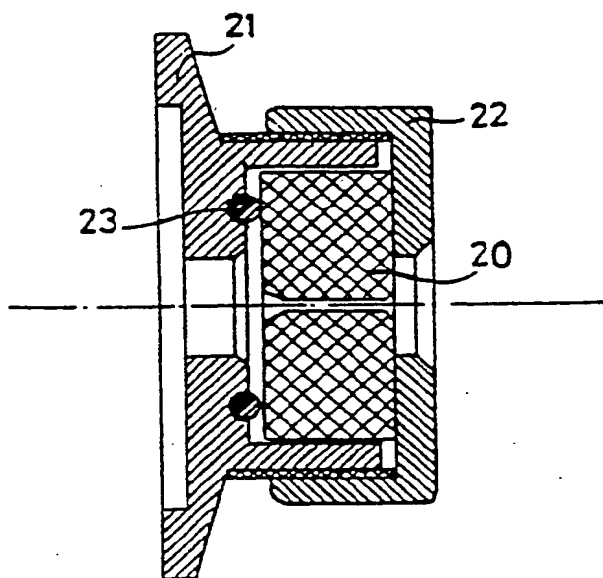


FIG. 2

Xerox Copy Centre

BEST AVAILABLE COPY

FEED-THROUGH ELEMENT FOR APPLICATION IN A VACUUM APPARATUS ; APPARATUS PROVIDED WITH SUCH FEED-THROUGH ELEMENTS AS WELL AS WIRE MATERIAL FORMED IN SUCH AN APPARATUS

The invention relates to a feed-through element for application in a vacuum apparatus for the continuous feeding through of wire-shaped material to be treated at least made up of a casing and a sealing element set up therein that is in contact with the surface of the wire-shaped material during feeding through.

Such feed-through element is known from British Patent Specification No. 1.428.933. In said publication is described a tubular feed-through element which can be inserted in the external wall of a vacuum-treatment apparatus or in the partition walls located between the different compartments of such apparatus. Said tubular feed-through elements consist of a casing and also of bored end flanges through which the wire-shaped material to be treated can be fed. Inside the casing there are bored sealing elements of material with a low friction coefficient and/or a good heat resistance, the bore being such that the outer surface of the wire-shaped material to be treated fits closely to the inner surface of the bore.

Such a known feed-through element has the disadvantage that the elements which fit closely to the wire-shaped material thereby forming a seal are subject to very high wear, the presence of such elements entailing a high degree of mechanical friction as a consequence of which the efforts necessary to feed the wire through may be very high. In addition, the wear mentioned hereinbefore occasions extra contamination of the wire surface, which may cause problems in later stages of the treatment and/or the use.

The treatment of material in a vacuum apparatus is in the present application to be understood as referring to the application of covering layers to the material by means of vacuum deposition or sputtering ; the carrying out of cleaning processes by means of vacuum ; the carrying out of heat treatments ; ion implantations, etc.

Surprisingly, it has been found that the above disadvantages attaching to the feed-through elements known in the prior art can be solved by the feed-through element according to the invention which is characterized in that the sealing element is formed by a drawing die and in that the casing is formed by a holder for the drawing die, at least a part of the holder being connected in a gastight way to a partition wall of the vacuum apparatus and the drawing die and the holder acting together in sealing relation.

By a drawing die as mentioned hereinabove is understood a means, known in the wire-products manufacturing industry, having the shape of a bored element generally made of hardened special steel or ceramic material. Such a die is used to reduce the diameter of metal wire under elongation by drawing. It has been found that a drawing die which is common in the wire manufacturing industry makes an excellent sealing element in a vacuum apparatus of the feed-through type. As is well-known, the drawing die has a feed-through aperture with a diameter that is smaller than the outside diameter of the wire to be fed through so that excellent sealing is obtained. If such a drawing die is inserted in a holder at least a part of which is inserted in a gastight way in a partition wall, the drawing die itself and the holder furthermore acting together in sealing relation, an extremely well functioning feed-through element will be obtained.

In particular, the feed-through element according to the invention is provided with a drawing die which causes a reduction not exceeding 2 %.

By reduction is in this case understood the quotient

$$\frac{\text{orig. } d^2 - \text{final } d^2}{\text{orig. } d^2} \times 100$$

As regards the desired sealing action of the drawing die applied, it has been found that a reduction not exceeding 2 % generally suffices ; in practice, a reduction of approximately 1 % is also highly satisfactory.

Surprisingly, when applying the feed-through elements according to the invention it was found that the utilization of such drawing dies as feed-through element offers considerable advantages as to the quality of certain treated products. In the case in which by means of a vacuum method a metal layer such as aluminium is applied, for instance, the layer applied is present on the wire material in the form of a crystalline aluminium layer containing a great many pores.

It has been found that if a feed-through element in the form of a drawing die is inserted at the end of the vacuum apparatus, there where the wire material leaves the apparatus, this drawing die will give evidence of a densifying action on the freshly deposited aluminium metal. The pores present are shut as it were by the drawing die, which will cause the final wire material to present a higher resistance to corrosion during use. In particular, sealing

material is inserted between the drawing die and the holder in the feed-through element according to the invention. A suitable form of sealing material is an O-ring, for instance. Advantageously, the holder of the drawing die of the feed-through element according to the invention can be inserted in a partition wall of a vacuum apparatus so that it can be detached. This way, it can be arranged that when changing from one wire type to another wire type, the change being small, it is possible to simply place another drawing die inside the holder. The detachability of the holder also allows a complete holder exchange in the case of great changes requiring a drawing die of another size.

The invention is also embodied in an apparatus for the treatment in vacuum of wire-shaped material, the material to be treated being continuously fed through the apparatus and the apparatus at least consisting of one or more chambers, means for feeding the material through, means for generating a vacuum and feed-through elements characterized in that at least part of the feed-through elements is formed by the feed-through element according to the invention.

In general, at least the feed-through element at the entry of the apparatus and at the exit of the apparatus will be formed by a feed-through element according to the invention. The feed-through elements in the partition walls between any chambers can also be formed by the feed-through element according to the invention; this is not necessary, however. The demands made upon the feed-through elements between the different chambers as to sealing action are less high because in this case there is a far smaller difference in pressure.

Finally, the invention relates to wire material provided with a metal covering layer which has been applied by means of a vacuum process. According to the invention, this wire material is characterized in that the vacuum process is carried out in the apparatus wherein at least part of the feed-through elements is formed by the feed-through element according to the invention and wherein particularly the feed-through element at the end of the apparatus, where the wire-shaped material leaves the apparatus, is formed by a feed-through element according to the invention. As indicated hereinbefore, such a feed-through element has a special effect in the case in which a metal layer is applied to wire-shaped material by means of a vacuum treatment. The presence of a feed-through element wherein at least a drawing die is inserted causes the pores present in the metal layer to be closed thus having a very positive effect on the corrosion resistance of the material.

The invention will hereinafter be illustrated with reference to the drawing, wherein

Figure 1 shows a schematic section through an apparatus for carrying out a vacuum treatment and wherein one or more feed-through elements according to the invention have been inserted:

Figure 2 shows a longitudinal section through a feed-through element according to the invention.

In figure 1, a vacuum-treatment apparatus for wire-shaped material is indicated with general reference number 1. In this case, the apparatus consists of several chambers 2, 3, 4, 5 and 6. Feed-through elements 7 and 12 have been inserted at the beginning and end of the apparatus whilst there are also feed-through elements 8 up to and including 11 between different chambers.

Each one of the chambers is connected to a vacuum source via an exit 13, 14, 15, 16 and 17. Generally, a so-called rough vacuum will be provided for instance in chambers 2 and 6 via connections 13 and 17, which is obtained by a pump with a very high pumping capacity creating a relatively low vacuum. The chamber 3 up to and including 5 are connected via their respective exits 14 up to and including 16 to vacuum sources that can create a high vacuum. In the apparatus herein described, at least the feed-through elements 7 and 12 will be formed by a feed-through element according to the invention; the feed-through elements indicated with 8, 9, 10 and 11 may be formed by other feed-through elements although the feed-through elements according to the invention can be utilized.

Figure 2 shows a drawing on an enlarged scale of a feed-through element according to the invention. The core of the feed-through element is the drawing die 20 that is inserted in a holder composed of 2 parts 21 and 22. The drawing die is retained between the holder parts 21 and 22 and is connected in a sealing way to the holder by means of O-ring 23. Either part 21 or part 22 of the holder can be connected in a gastight way to a partition wall of the apparatus. As indicated hereinbefore, this gastight connection is advantageously detachable so that it is possible not only to replace or to exchange the drawing die in the same holder but also to replace the complete holder by a holder which allows to fit a drawing die of another size.

Claims

1. Feed-through element for application in a vacuum apparatus for the continuous feeding through of wire-shaped material to be treated at least made up of a casing and a sealing element set up therein that is in contact with the surface of the wire-shaped material during feeding through, characterized in that the sealing element is formed

by a drawing die (20) and in that the casing is formed by a holder (21 ; 22) for the drawing die (20), at least a part of the holder (21 ; 22) being connected in a gastight way to a partition wall of the vacuum apparatus (1) and in that the drawing die (20) and the holder (21 ; 22) act together in sealing relation.

2. Feed-through element according to claim 1, characterized in that the drawing die (20) causes a reduction not exceeding 2 %.

3. Feed-through element according to claim 1 and 2, characterized in that sealing material (23) is inserted between the drawing die (20) and the holder (21, 22).

4. Feed-through element according to claims 1 - 3, characterized in that the holder (21 ; 22) can be inserted in a partition wall of a vacuum apparatus (1) so that it can be detached.

5. Apparatus for the treatment in vacuum of wire-shaped material, the material to be treated being continuously fed through the apparatus and the apparatus at least consisting of one or more chambers, means for feeding the material through, means for generating a vacuum and feed-through elements, characterized in that at least part of the feed-through elements is formed by the feed-through element according to one or more of claims 1 - 4.

6. Wire material provided with a metal covering layer which has been applied by means of a vacuum process, characterized in that the vacuum process is carried out in the apparatus according to claim 5 wherein a feed-through element according to the invention has been provided at least there where the wire leaves the apparatus.

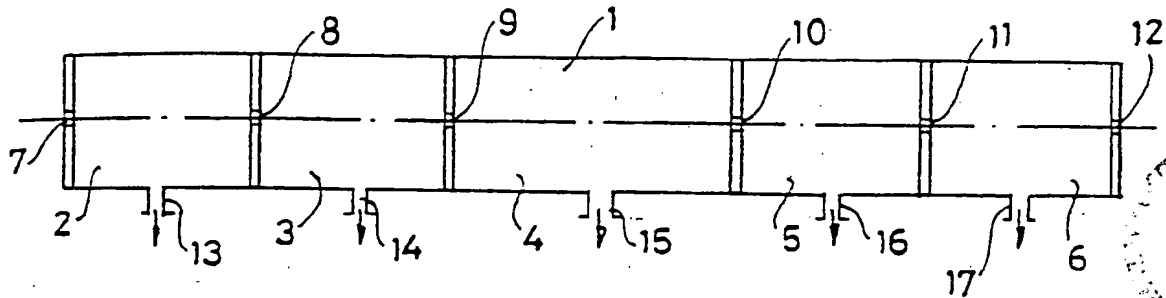


FIG. 1

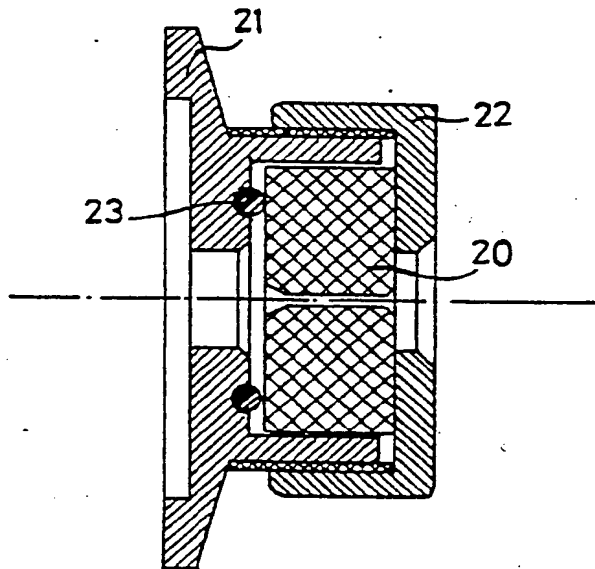


FIG. 2

BEST AVAILABLE COPY



European Patent
Office

EUROPEAN SEARCH REPORT

Application Number

EP 87 20 1986

DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 4)
X	FR-A-2 315 645 (THE ELECTRICITY COUNCIL et al.) * Claims; figures * --- A, B GB-A-1 428 993 (THE ELECTRICITY COUNCIL) -----	1, 5, 6	C 21 D 9/56 C 23 C 14/56 F 16 J 15/16
			TECHNICAL FIELDS SEARCHED (Int. Cl. 4)
			C 21 D C 23 C F 16 J

The present search report has been drawn up for all claims

Place of search THE HAGUE	Date of completion of the search 13-01-1988	Examiner MOLLET G.H.J.
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons ----- & : member of the same patent family, corresponding document		

EPO FORM 1503 03.82 (P0401)